

## Patent claims:

1. A pump, e.g., for conveying lubricating oil in an internal combustion engine, in particular a multi-stroke vane-cell pump in which the rotatable group has a rotor (7) having vanes (3) that are movable at least radially, a stroke profile along which the vane heads of vanes (3) slide tightly, and two axial lateral lids such as lateral plates or casing walls, characterized in that the stroke profile and a first axial lateral plate are formed by a sheet metal pot (1).
2. The pump as recited in Claim 1, characterized in that the sheet metal pot (1) is manufacturable by deep drawing.
3. The pump as recited in Claim 1 or Claim 2, characterized in that a second axial lateral plate is formed by a sheet metal lid (40).
4. The pump as recited in Claim 3, characterized in that the sheet metal lid (40) has an impressed shoulder (44) whose outside profile is in the shape of the stroke profile.
5. The pump as recited in Claim 3 or Claim 4, characterized in that the sheet metal lid (44) is manufacturable by precision blanking or fine-edge blanking.
6. The pump as recited in Claims 1 through 5, characterized in that the intake openings are formed by radial openings (46, 48) in the sheet metal pot (1).
7. The pump as recited in Claims 1 through 6, characterized in that the outlet openings are formed by axial openings (15.1, 15.2) (pressure pockets) and, if necessary, at least one radial opening (56) in the sheet metal pot.

8. The pump as recited in Claim 7,  
characterized in that the radial outlet opening (56) is sealable by a temperature switching valve (19) or a pressure switching valve and thus establishes a switchable conveyor area.
9. The pump as recited in Claim 8,  
characterized in that the temperature switching valve (19) has an excess stroke spring (58).
10. The pump as recited in one of the preceding claims,  
characterized in that the sheet metal pot (19) of the rotatable group and, if necessary, the temperature switching valve (19) or the pressure switching valve are integrated into a plastic casing (1).
11. The pump as recited in Claim 10,  
characterized in that the plastic casing (11) is finished by injection molding and therefore needs no reworking.
12. The pump as recited in one of the preceding claims,  
characterized in that the axial outlet opening (15.1) of the switchable conveyor area is closable by a reed nonreturn valve (64).
13. The pump as recited in Claim 12,  
characterized in that the reed nonreturn valve has the shape of the stroke profile curvature.
14. The pump as recited in Claim 12 or 13,  
characterized in that the reed nonreturn valve (64) is mounted on a plastic journal (74).
15. The pump as recited in Claims 12 through 14,  
characterized in that a stroke end stop (76) is provided for the reed nonreturn valve (64) in the plastic casing (11).

16. The pump as recited in one of the preceding claims,  
characterized in that the sheet metal pot (1) has a notched or impressed cold start ring (54,  
54.1, 54.2).
17. The pump as recited in Claim 16,  
characterized in that the rotor (7) has grooves or depressions to receive the cold start ring  
(54, 54.1, 54.2).
18. The pump as recited in Claim 16 or 17,  
characterized in that the sheet metal lid (40) has a notched or impressed cold start ring.
19. The pump as recited in one of the preceding claims,  
characterized in that the sheet metal lid (40) has impressed apparent pressure pockets.
20. The pump as recited in one of the preceding claims,  
characterized in that the radial outlet opening (56) of the switchable conveyor area opens into  
a channel (13), which opens directly via a short path into the intake area (17.2) of the second  
nonswitchable conveyor area.